



WORK ORDER 2007-09

Date opened: 26 November 2007

Project: Quick Release Cargo Basket Beams
Type: Bell 206L Series, 407Batch Quantity: 9 Forward Beam Assy (Stainless) (69830-02)
9 Aft Beam Ass'y (Stainless) (69831-02)Approval: SH00-48
Drawing List: DCL698-1


<u>Fabrication and Assembly Drawing(s)</u>	<u>Description</u>
69830, Rev. 2	Forward Beam Ass'y
69831, Rev. 2	Aft Beam Ass'y

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y ✓</u>
Document Control List revision level matches (or exceeds) STC:	<u>Y ✓</u>
Drawings revision levels match Document Control List:	<u>Y ✓</u>
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y ✓</u>
Tests and inspections specifically called out on drawings are complete:	<u>Y ✓</u>
Release tags associated with all fabricated parts are attached:	<u>Y ✓</u>
All mounting hardware and supplies are included:	<u>Y ✓</u>

List all non-conformities raised: _____

Inspector Signature:  Date: May 22/08

WELDER SIGNATURE: _____

DATE: _____

Drawing: 69830 Revision 2
 Assembly: 69830-02 Forward Beam Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
9 Total	69830-02	Forward Beam Assembly			
1	69830-13	Tube	304 Stainless, 1x2x0.125 tube	7006	
1	69830-14	Tube	304 Stainless, 1x2x0.125 tube	7006	
2	69830-15	Bushing	316 Stainless, 5/8" x 0.120 tube	7008	
1	69830-16	Strap	304 Stainless, 0.105" Sheet	7006	
1	69830-17	Block	304 Stainless, 1/4" Sqr. Rod	7016	
1	69830-19	Cap	321 Stainless, 0.032" Sheet	3021	
1	69830-20	Cap	321 Stainless, 0.032" Sheet	3021	
1	69830-11	Guide	304 Stainless, 3/4" x 0.065" Rnd. Tube	6049	
1	69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	6061	
1	69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	3005	
1	69830-23	Spring	15mm x 70 mm Spring	6063	
1	#10-32	Screw	Stainless Steel, Commercial	6069	
1	MS21044C3	Nut		1013	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Powder Coat	Drawing 69830			
Final Inspection	Drawing 69830			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 69831 Revision 2
 Assembly: 69831-01 Aft Beam Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
9 Total	69831-02	Aft Beam Assembly			
1	69831-13	Tube	304 Stainless, 1x2x0.125 tube	7006	
1	69831-14	Tube	304 Stainless, 1x2x0.125 tube	7006	
1	69831-15	Tube	304 Stainless, 1x2x0.125 tube	7006	
2	69830-15	Bushing	316 Stainless, 5/8" x 0.120 tube	7008	
1	69830-16	Strap	304 Stainless, 0.105" Sheet	7006	
1	69830-17	Block	304 Stainless, 1/4" Sqr. Rod	7016	
1	69830-19	Cap	321 Stainless, 0.032" Sheet	3021	
1	69830-20	Cap	321 Stainless, 0.032" Sheet	3021	
1	69830-11	Guide	304 Stainless, 3/4" x 0.065" Rnd. Tube	6049	
1	69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	6061	
1	69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	3005	
1	69830-23	Spring	15mm x 70 mm Spring	6063	
1	#10-32	Screw	Stainless Steel, Commercial	6069	
1	MS21044C3	Nut		1013	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Powder Coat	Drawing 69831			
Final Inspection	Drawing 69831			

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Tag complete parts / assemblies with Release Tag prior to storage.

E+B

AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Quick Release Forward Beam Part #: 69830-02

Approval #: SH00-48 Serial #: --

WO #: 2007-20 Quantity: 1

Eligibility: Bell 206L / 407 Work Status: Manufactured

Remarks: _____

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

April 6/05
Date

Jeff Clark
Inspector's Signature

AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

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TRANSPORT CANADA
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AMF # 73-04

Product: Quick Release Aft Beam Part #: 69831-02

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May 22 / 08
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[Signature]
Inspector's Signature

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May 14/04 [Signature]
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ELBOW
RIVER
HELI

CC HELI

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June 23/09
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Jeff Clarke
Inspector's Signature

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2013 - 39th Ave. NE
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